

GREEN

Dart Aerospace Ltd.

Date: Wednesday, 9/6/2006 3:46:56 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : SKID TUBE ASSEMBLY

Job Number : 28449

Estimate Number : 12520

P.O. Number : N/A

This Issue : 9/6/2006

S.O. No. : N/A

Prsht Rev. : NC

First Issue : N/A

Type : LANDING GEAR

Previous Run : N/A

Part Number : D205634045

Drawing Number : D2580 REV C/DEO9183B

Project Number : N/A

Drawing Revision : C/B

Material : N/A

Due Date : 9/30/2006

Qty: 6 Um: Each

Written By :

Checked & Approved By :

Comment : Est Rev:C Revised Steps 06-09-06 JLM

Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL

Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile & type labels per PPP D205-634-045 CHG001

KS 06110/12

2.0

D25001190

Ext'n - 1" Beam Tube 4"

Comment: Qty.: 1.0400 Each(s)/Unit Total: 6.2400 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2500-1-190

Skid Tube Extrusion

B24669 BE 06-09-12

3.0

D2596

205 Web

Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2596

205 Web

B28493 BE 06-09-13

4.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessary Debur ends

3-Drill pilot holes using drill jig DT 8149

4-Acid etch and Alodine tube per QSI 005 4-1

5-Open holes to 0.500" as per Dwg D2580 without cutting fluid

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Job Number: 28449

Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6-Countersink holes as per Dwg D2580 without cutting fluid

BE 06-09-13

7-Deburr and blow out all chips from inside of tube

BE 06-09-13

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

BE 06-09-13

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 m 101953

Sikaflex expire date: 06-10-21

Start Time: 06-09-13 Date: 06-09-13

Fin Time: 7:30am Date: 06-09-13

Pmc 06-9-18

5.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

DP 6-9-18

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends after cutting. Remove alodine from around holes

2-Drill extra fwd hole as per DEO 9183 using
drill jig DT8461

3-Drill extra middle hole as per DEO 9183 using
drill jig DT8462

4-Drill extra aft holes as per DEO 9183 using
drill jig DT8463 & DT8091

Pmc 06-9-19 (6)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 06-09-19 (6)

8.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
	2								

Part No: 11 PAR #: 2 Fault Category: 2 NCR: Yes No DQA: 3 Date: 1/1/00
 QA: N/C Closed: 3 Date: 1/1/00

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 28449

Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description:

1

D2576-3

Step

B23060 BE 06-09-21 (6)

9.0

D2579

Crossbolt Spacer



Comment: Qty.: 24.0000 Each(s)/Unit Total: 144.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

24

D2579

Spacers

B27167 BE 06-09-21 (144)

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 Step Remove alodine as required.

BE 06-09-21 (6)

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

M101655

BE 06-09-21 (6)

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004. For D2579 side, pass 3/8" drill, weld other side, pass 3/8" drill

spacers, weld one

A/R

Aluminum Rod

M101655

BE 06-09-21

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

pm/a/DA

5-Drill holes for wearplates using DT 8217 Open holes to 19/64", adjust stopper not to hit web. Deburr

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

*****DO NOT COUNTERBORE EXTRA HOLES PUT IN AT STEP 13,14 AND 15 (LEAVE AT 0.384" Ø AS PER DEO 9183)*****

pm
06-09-28 (6)

7-Drill pilot holes for aft cap using DT 8215 Open holes to #6 Drill bit. Deburr

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

11.0

QC5/9

WELD INSPECTION



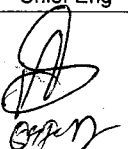
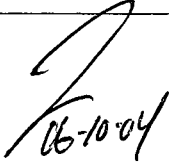
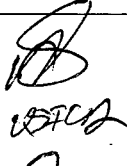

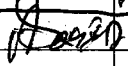

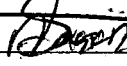
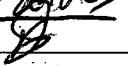
Comment: WELD INSPECTION

Inspect weld and Counterbore work to Step 20

PD 06-09-28 (6)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DB Date: 06/10/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-10-03	10.0	^{Added} 3 holes cross bolt spacers were installed on the CL of the outside ridge. Possible misalignment due to unit bit grabbing and ovalizing the hole. 0.085" below CL at the most.		Remove and replace the 3 extra cross bolt spacers, and reinstall new. B 27921. Ensure spacer is centered, and re-weld as per QSI 004.	BE 06-10-04			
				Inspect level 925	06-10-04			

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Job Number: 28449

Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

* Powder Coat ****GREEN****Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

Ham 06/10/05

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 005 (3) a.m 06-10-06 (3)

14.0

D25771

Wearplate Fwd



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-1	Wearplate	<i>326350</i>

15.0

D25773

Wearplate Aft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-3	Wearplate	<i>326058</i>

16.0

D25775

Wearplate, Centre



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-5	Wearplate	<i>24878</i>

17.0

ALS71032130

Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total : 264.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
44	ALS7-1032-130	Inserts	<i>m 19393</i>

a.m 06-10-05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 28449

Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960JD10L

Washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 264.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4 4	AN960JD10L	Washer	m100233

19.0

AN34A

Bolt



Comment: Qty.: 44.0000 Each(s)/Unit Total : 264.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
44	AN3-4A	Bolt	m101677

20.0

D25941

Plug



Comment: Qty.: 16.0000 Each(s)/Unit Total : 96.0000 Each(s)

plug

Batch: ~~210290~~ B 28452

21.0

D25943

O-Ring



Comment: Qty.: 16.0000 Each(s)/Unit Total : 96.0000 Each(s)

o-ring

Batch: B 2404

22.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Cap

Batch: ~~526351~~ B 27488-1

23.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Batch: m15205 4-m 06-10-05

Q

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Job Number: 28449

Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Washer

Batch: M100233

Q.M 06-10-05 (6)

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Black Sikaflex-291 M102051

Sikaflex expire date: 02-2007

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 M102051

Sikaflex expire date: 02-2007

Q.M 06-10-05 (6)

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

M102098

Batch:

Q.M 06-10-06 (6)

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-045

Location: _____

PPP Rev: _____

M/D 06/10/13

28.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/16 (6)

h 06-10-13

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. C SHEET 1 OF 2
DATE 98.08.26		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	

RELEASED
98/09/17 DS

QTY	Part Number	Description
X	D2580-041	SKIDTUBE ASSEMBLY
*	D2500-1	EXTRUSION
1	D2596	205 WEB
1	D2575	AFT CAP
1	D2576 - 3	STEP
20	D2579	CROSS BOLT SPACER
16	D2594-1	PLUG
16	D2594-3	O-RING
1	D2577-1	WEARSHOE
1	D2577-3	WEARSHOE
1	D2577-5	WEARSHOE
44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
46	AN3-4A	BOLT
46	AN960JD10L	WASHER

00.08.28
UP 00.08.28

EFFECTIVE	DEOS
98/12/14	98/12/14
DEO 9124	DEO 9183

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES *
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (44 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB.
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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WORK ORDER
NO.

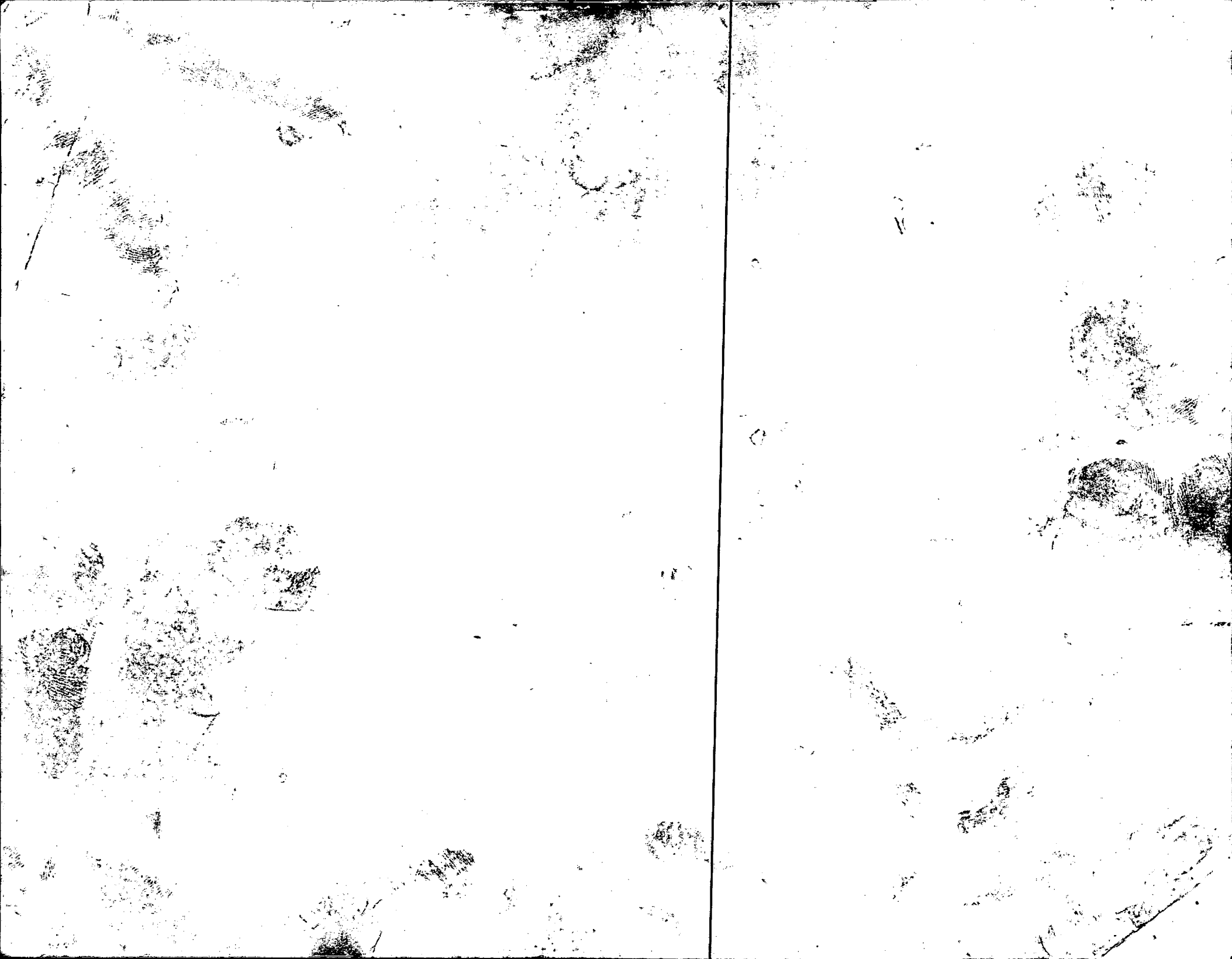


Diagram of a propeller hub with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- GRIND FLUSH STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576
- 1/4

Technical drawing of a bolted joint. The drawing shows a circular cross-section of a component with a central hole. A bolt is shown passing through the hole. The following labels and instructions are present:

- DRILL PRIOR TO D2575 CAP INSTALLATION (2 PLACES)
- Ø.0208
- AN3-4A BOLT (1)
- AN96QJ10L WASHER (1)
- (2 PLACES)
- D2575 CAP
- SEAL WITH SIKAFLEX-241

D2579 SPACER
 D2596 WEB (REF)
 ALS7-1032-130 (REF)
 (TYP 44 PLACES)

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

[illegible]

Figure 1 is an elevation view of a road cross-section. It shows a 1:1 slope on the left, a 10% grade in the center, and a 1:1 slope on the right. The road width is 11.0. The distance between the hole and the tangent point is 1.0. The distance between the hole and the tangent point is 13.4. The distance between the hole and the tangent point is 32.0. The diagram also shows a 1.4 offset and a 20.0 offset. A 0.640 offset is also indicated.

WELD AS PER DETAIL B

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

0.5 1.5 1.5 1.5 D P P P P P P P

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

1.5 1.5 1.5

REFER TO DETAIL C

D2577-3

D2577-5

D2577-1

8

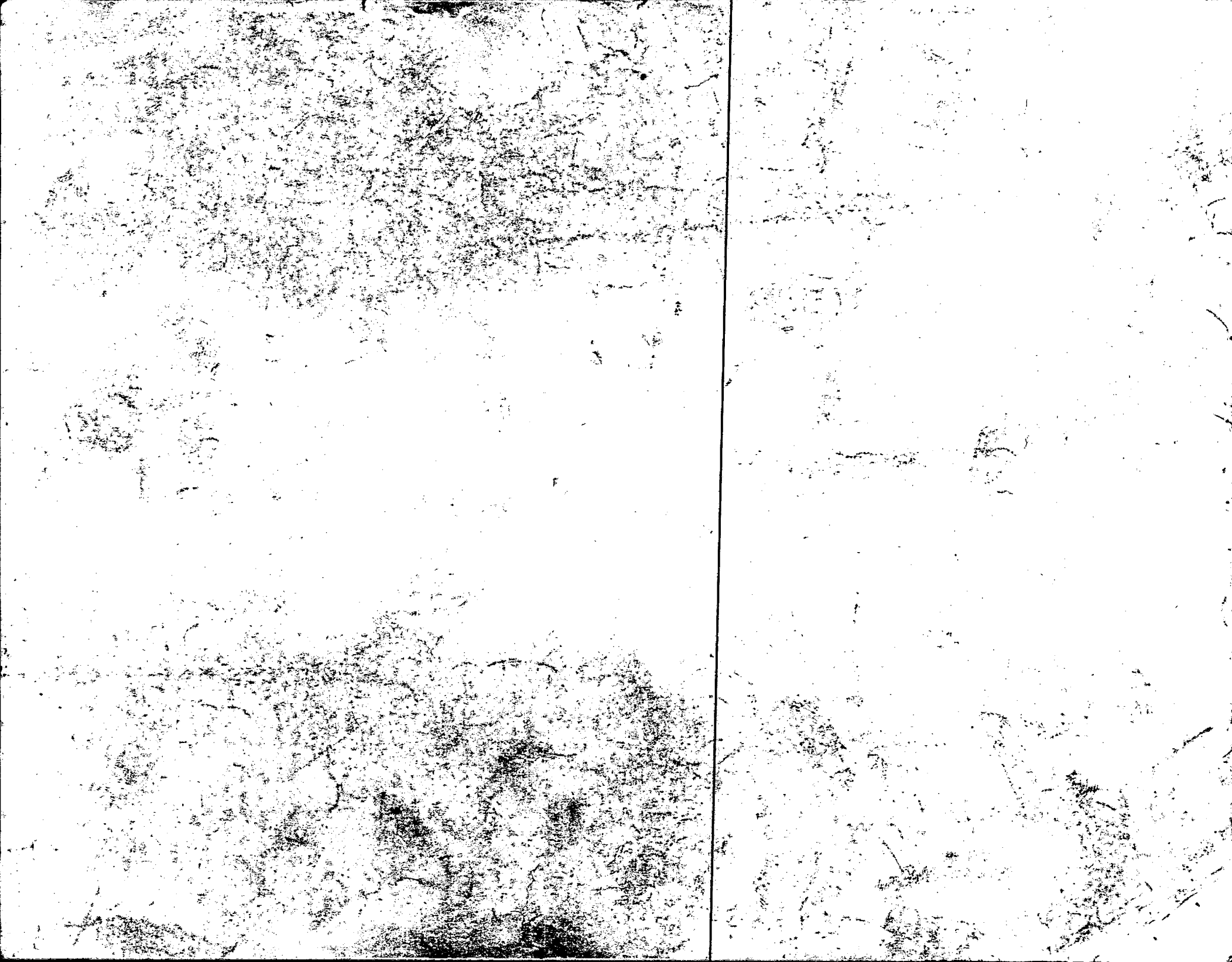
AN3-4A BOLT (1)
AN96QJ10L WASHER (1)
(44 PLACES)

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	PAB
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AN3-4A BOLT (1)
AN960JD10L WASHER (1)
(44 PLACES)

DESIGN <i>DAF</i>	DRAWN BY <i>CP</i>	DART	DART AEROSPACE LTD HARRISBURY, ONTARIO, CANADA
CHECKED <i>DAF</i>	APPROVED <i>JS</i>		
DATE 98.08.26		TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24

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DART

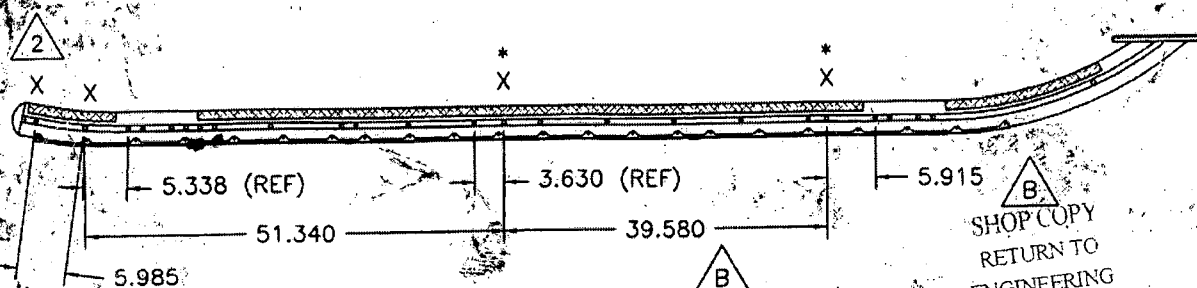
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. DEO 9183	REV. B SHEET 1 OF 1
DATE 00.05.15		TITLE ADD SKIDTUBE P/N D2580-045	SCALE NTS
A	00.03.29	NEW ISSUE	
B	00.05.15	39.580 WAS 39.620	

DART ENGINEERING ORDER

AMEND DRAWING D2580 REV. C TO ADD D2580-045 ASSEMBLY

D2580-045 IS IDENTICAL TO D2580-041, EXCEPT FOR THE FOLLOWING CHANGES:

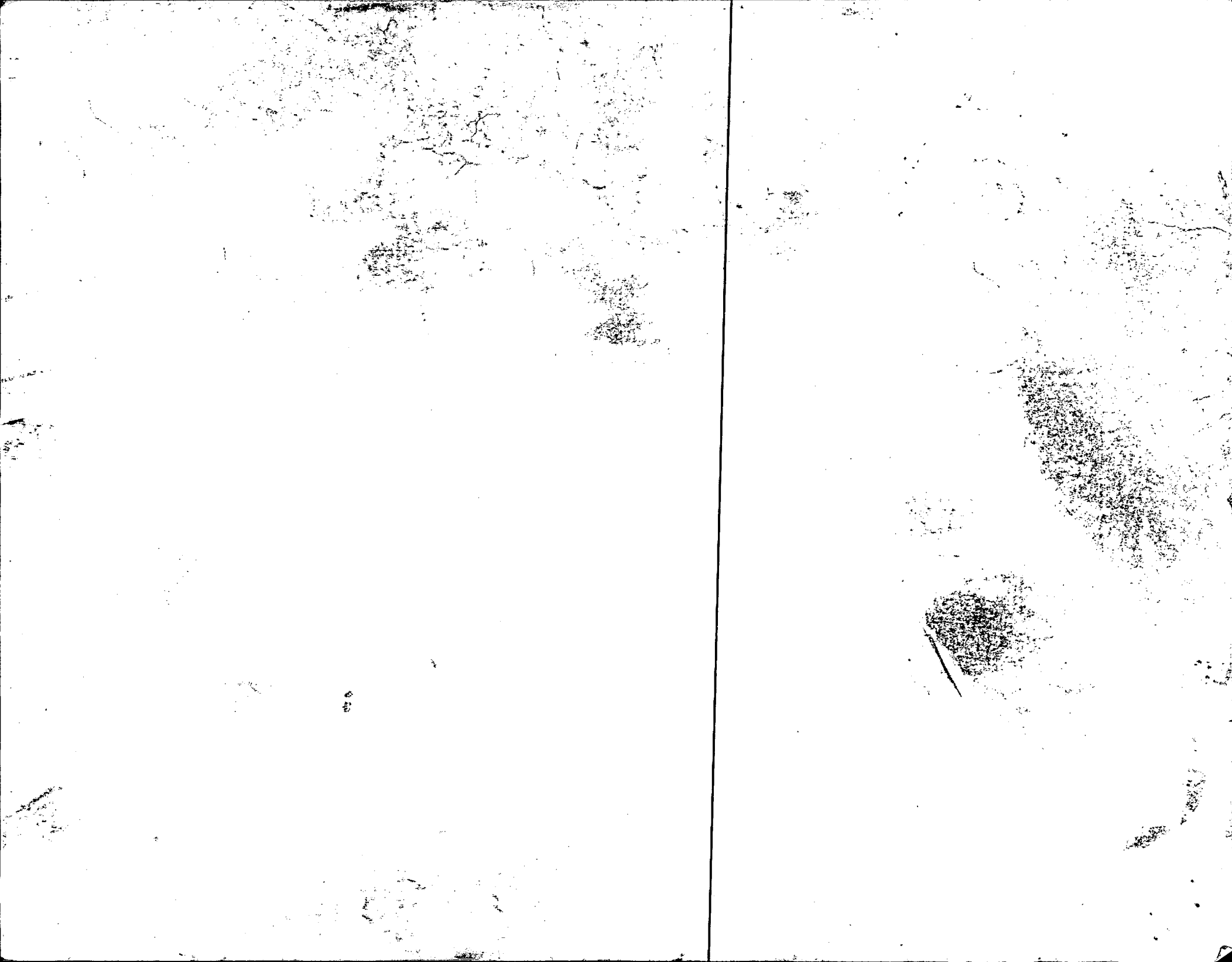
- 1) INSTALL CROSS BOLT SPACERS AT LOCATIONS MARKED 'X' ACCORDING TO THE FOLLOWING PROCEDURE.
 - a) DRILL $\varnothing 0.508$ HOLES AT LOCATIONS SHOWN BELOW MARKED 'X'. CHAMFER HOLES $0.030 \times 45^\circ$. NOTE THAT HOLES WILL ALSO HAVE TO BE TRANSFERRED TO THE D2596 WEB AT THE * LOCATIONS. IT IS ACCEPTABLE TO PRE-DRILL THE D2596 WEB IN THESE LOCATIONS BEFORE INSTALLING THE WEB IN THE SKIDTUBE. OPEN HOLES TO $\varnothing 0.63$ AND TOUCH UP WITH ALODINE PER QSI 005 4.1.
 - b) INSERT D2579 CROSS BOLT SPACERS INTO THE HOLES.
 - c) WELD INTO PLACE PER DART QSI 004 AND GRIND FLUSH.
 - d) REMOVE SPILL OVER LEAVING HOLE DIMENSION $\varnothing 0.380$ - $\varnothing 0.390$.
- 2) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION.
- 3) POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 INSTEAD OF WHITE (REF. 4.3.5.1).



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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSI 9184	REV. A SHEET 1 OF 1
DATE 00.03.29		TITLE ADD SKIDTUBE P/N D205-634-015	SCALE NTS
A	00.03.29	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-634 REV. B.

REF. CANADIAN STA: SH96-88
US FAA STC: SR00563NY

ADD D205-634-015 INSTALLATION. PARTS LIST IS IDENTICAL
TO PARTS LIST FOR D205-634-011 EXCEPT THAT:
D205-634-045 REPLACES D205-634-041
D2580-045 REPLACES D2580-041

THE DIFFERENCE BETWEEN D205-634-011 (D205-634-041)
AND D205-634-015 (D205-634-045) IS THAT EXTRA
SPACERS HAVE BEEN ADDED AT LOCATIONS MARKED 'X' AND
ASSEMBLY IS PAINTED GREEN.



D205-634-015 (D205-634-045)

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NO. 9

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number D205634045 / B28449

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into 205 Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐

Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/09/19 Qualifier David Newel

